

Date: Friday, 6/1/2007 1:02:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 32737	
Estimate Number : 12736	
P.O. Number : <i>N/A</i>	Part Number : D353515
This Issue : 6/1/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3535 UNDER REVIEW
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : <i>AB</i> <i>PH 07.06.01</i>
Previous Run : 31990	Material : <i>N/A</i>
Written By : <i>JA</i>	Due Date : 6/8/2007 Qty: 20 Um: Each
Checked & Approved By : <i>JA 07.06.01</i>	
Comment : Est Rev:A New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total : 21.4305 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *M104640**ml 07 06 08**(20)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *B*Prog Rev: *B**ml 07 06 08**(20)*

2-Deburr if necessary

*mf**07-06-19**(20)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*ml 07 06 08**(20)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/06/18 (x70)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-15

*mf**07-06-20**SB 07/06/21**(20)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 01/06/26
 QA: N/G ~~Checked~~: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32737

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/06/21 *Conte* *(20)*

7.0

POWDER COATING

POWDER COATING



M 101 601



(20X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/06/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/06/25 *(20)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(20X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EP-15*

M-L 07/06/25

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/26

Job Completion



U 07/06/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32737
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.893	✓		vern	
2.000	+/-0.010	2.000	✓		M-T	
5.650	+/-0.010	5.650	✓		M-T	
9.150	+/-0.010	9.150	✓		M-T	
14.400	+/-0.010	14.400	✓		M-T	
19.650	+/-0.010	19.650	✓		M-T	
24.900	+/-0.010	24.900	✓		M-T	
30.150	+/-0.010	30.150	✓		M.T	
33.650	+/-0.010	33.650	✓		M.T	
35.650	+/-0.010	35.650	✓		M.T	
39.150	+/-0.010	39.150	✓		M.T	
Ø0.188	+0.005/-0.001	0.190	✓		vern	
24.00	+/-0.030	24.00	✓		M.T	
16.00	+/-0.030	16.00	✓		M.T	
8.00	+/-0.030	8.00	✓		M.T	
5.00	+/-0.030	5.00	✓		M.T	
0.300	+/-0.010	0.297	✓		vern	
0.300	+/-0.010	0.300	✓		vern	
0.038	+/-0.010	0.037	✓		vern	

Measured by:	<i>MM. MM</i>
Date:	07 06 08

Audited by:	<i>En</i>
Date:	07/06/08

Prototype Approval:	N/A
Date:	N/A

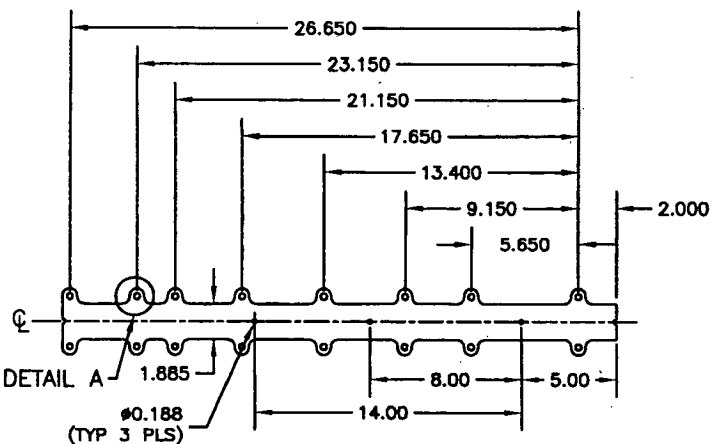
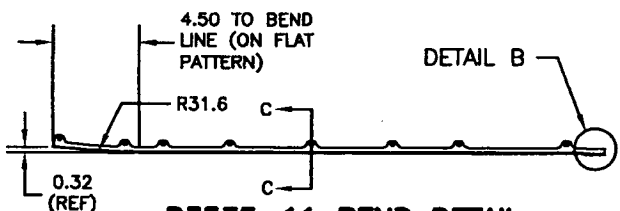
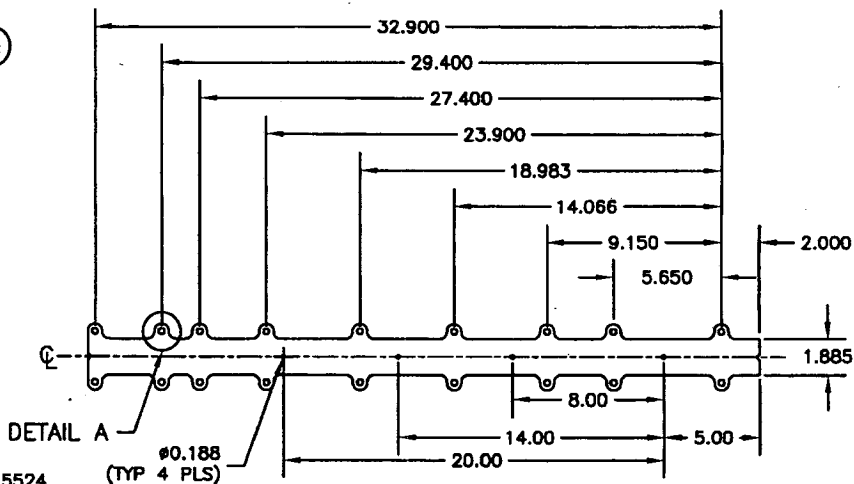
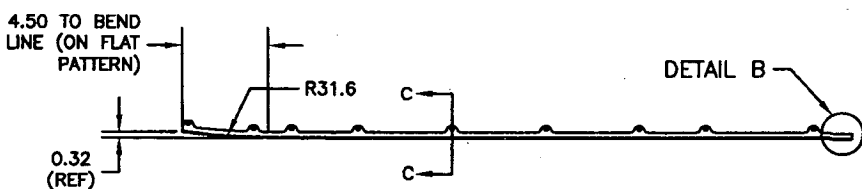
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

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07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
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		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

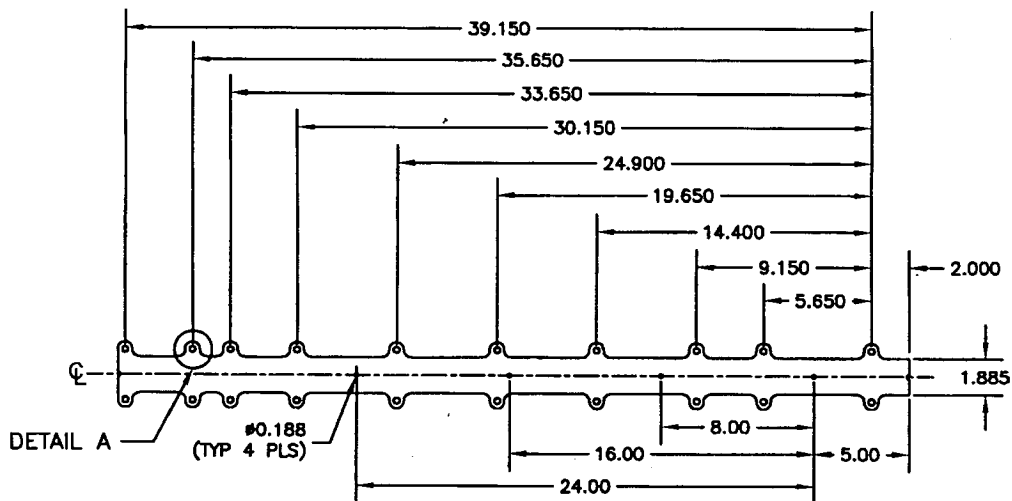
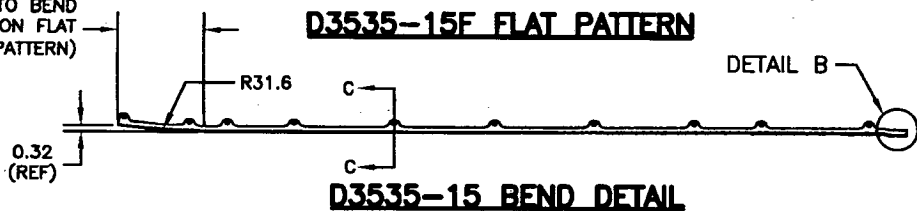
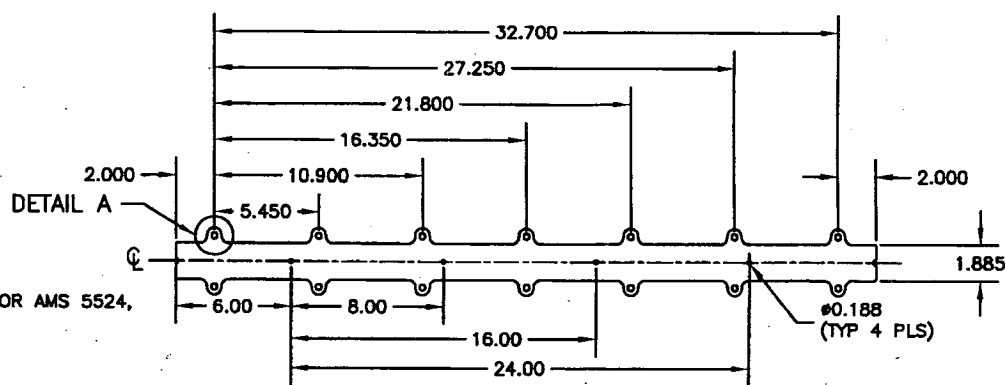
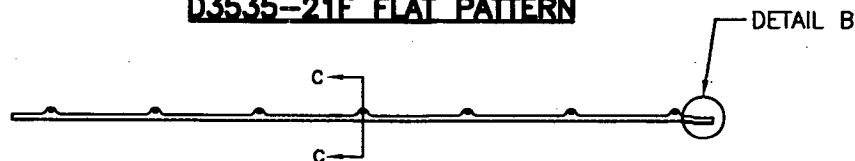
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4.50 TO BEND
LINE (ON FLAT
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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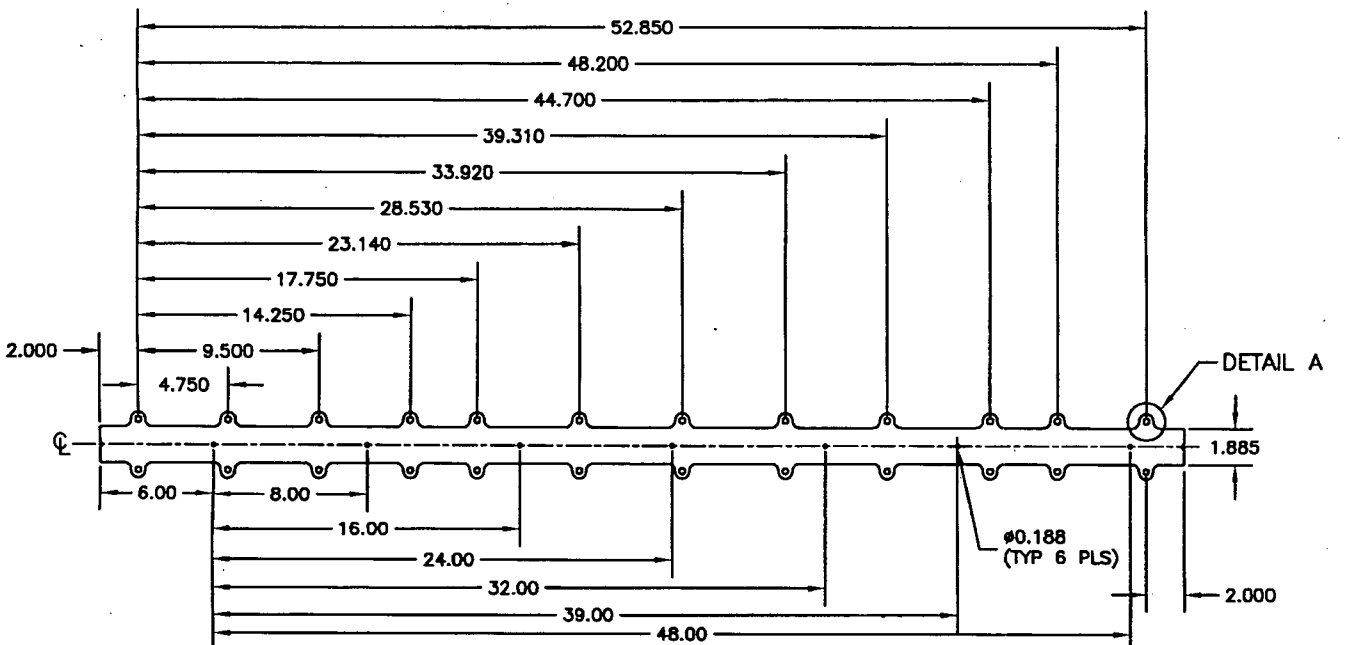
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07.04.17	WEARSHOE	SCALE
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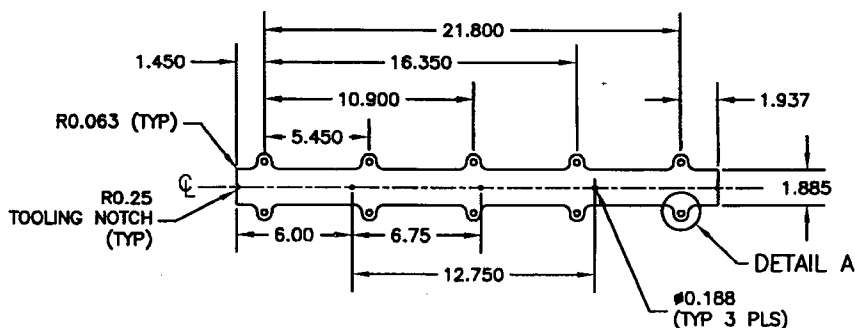
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D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

NOTES

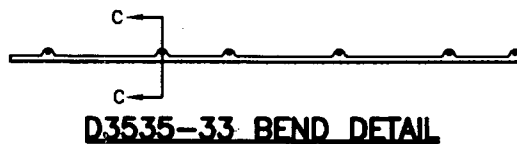
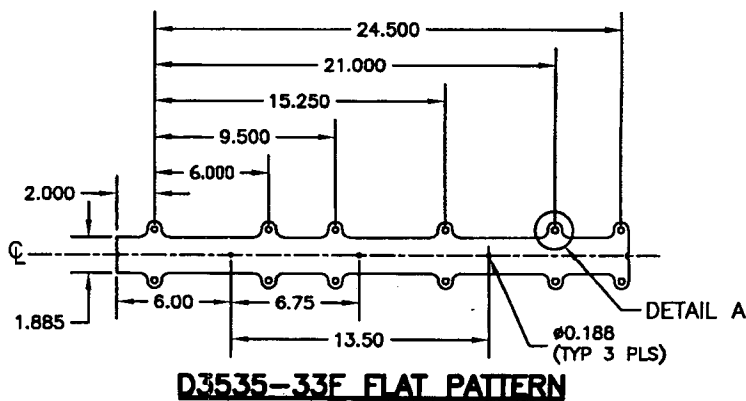
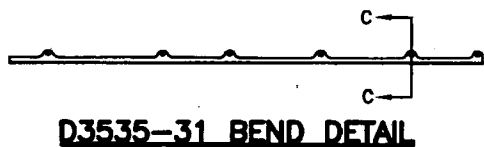
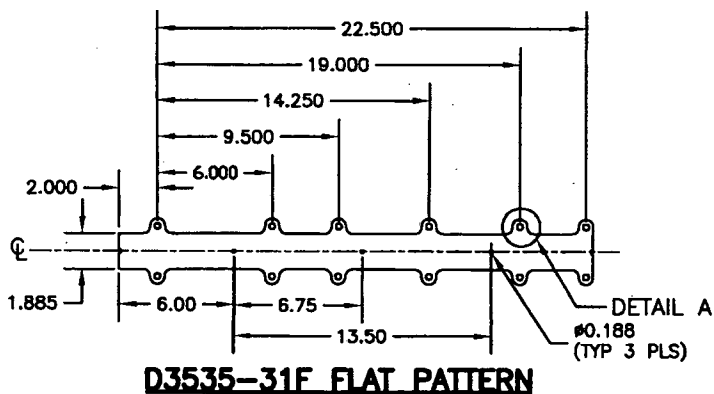
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		TITLE	WEARSHOE	SHEET 4 OF 7
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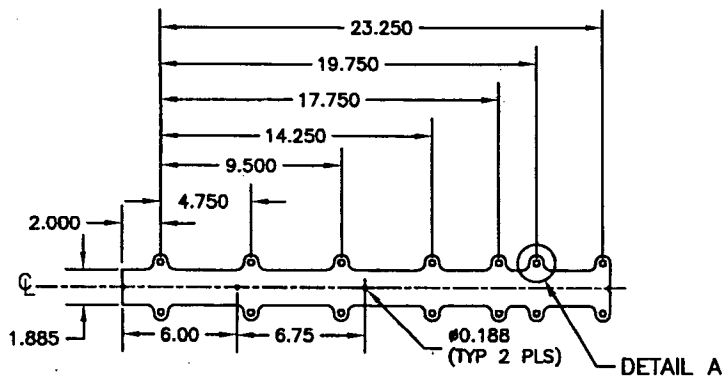
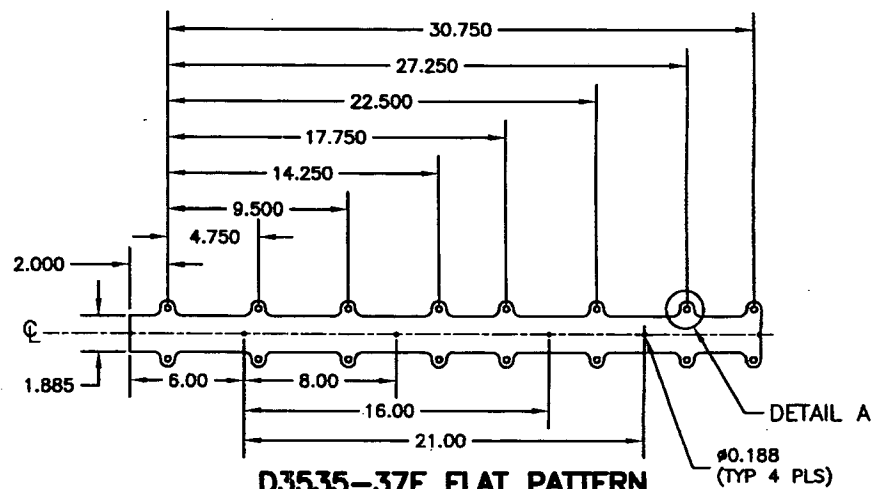
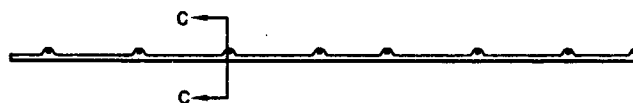
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**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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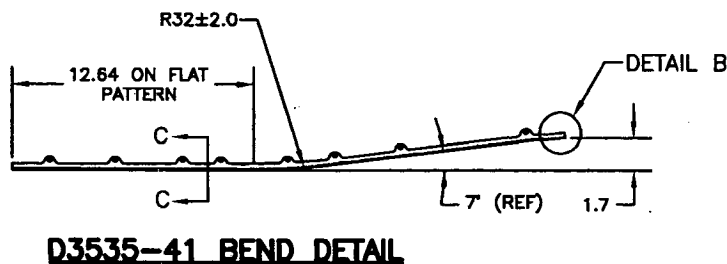
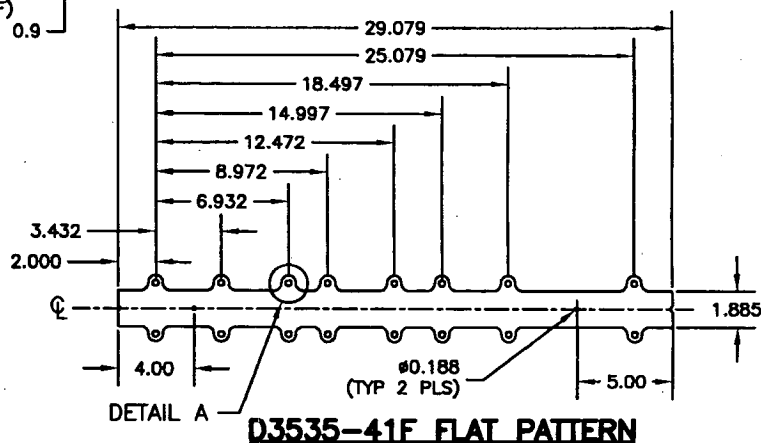
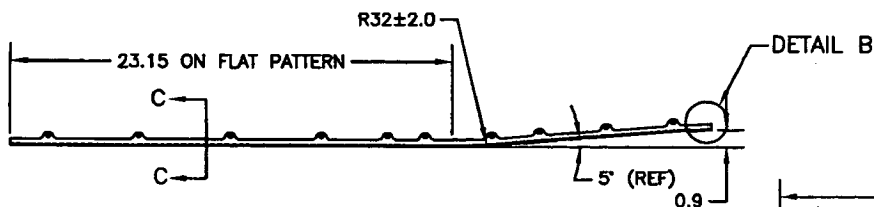
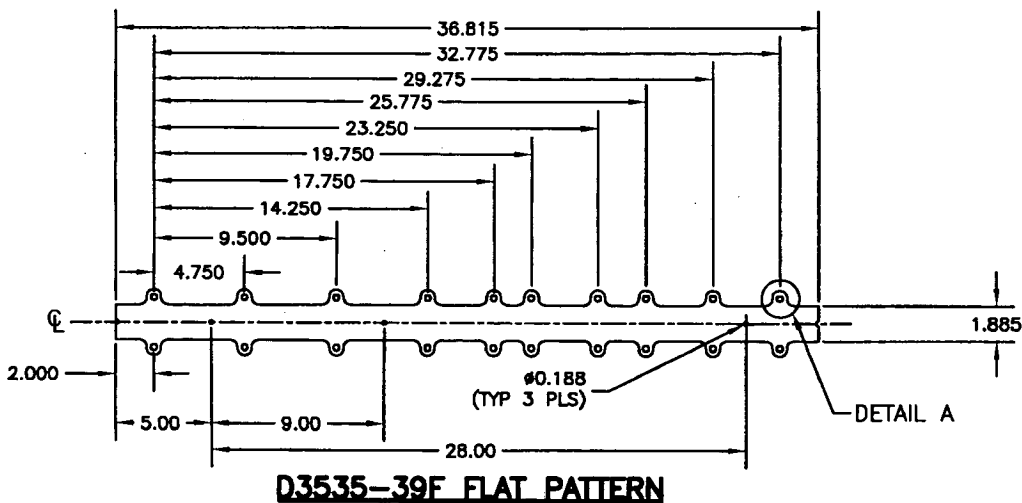
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DATE	TITLE	SCALE	
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		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



- NOTES**
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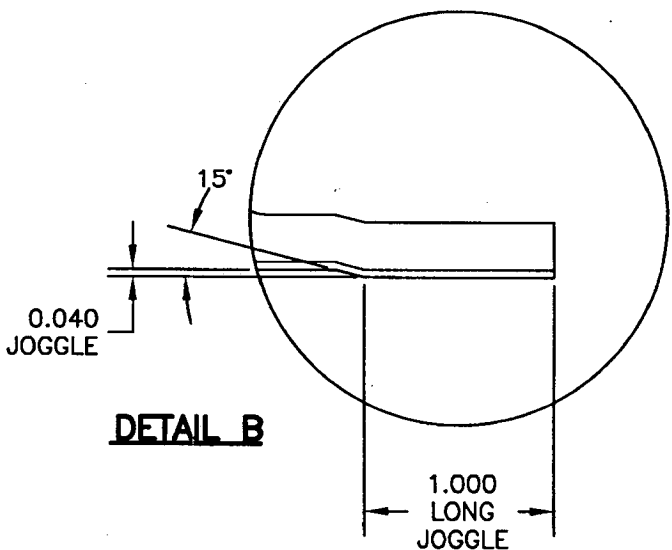
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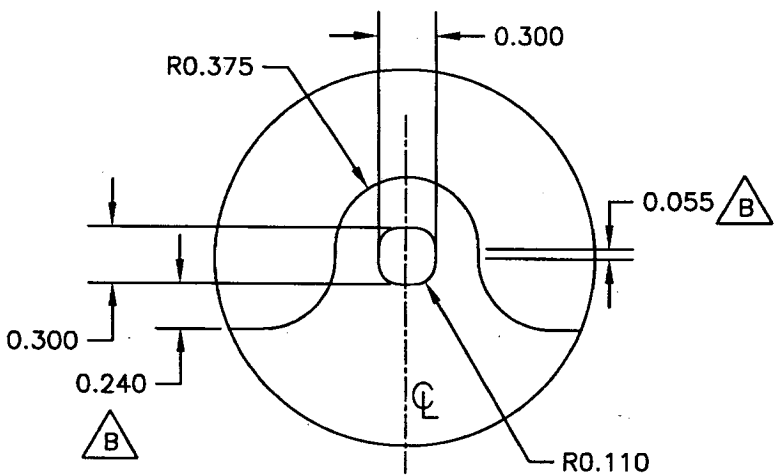
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DATE	07.04.17	TITLE	WEARSHOE	REV. B
				SHEET 7 OF 7
				SCALE 1:1

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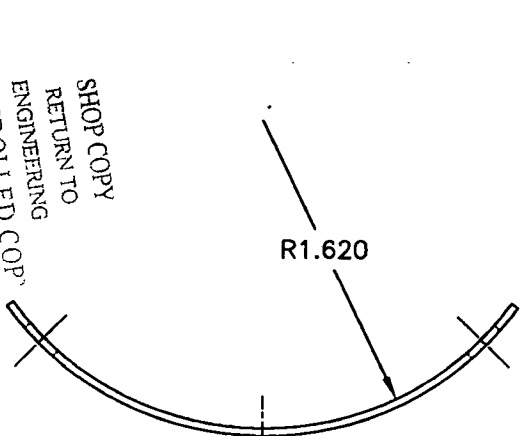
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DETAIL B



DETAIL A



SECTION C-C

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